

• Work Order ID 128529

128529

Page 1

Friday, January 16, 2015 2:51:20 PM

Item ID: D4866-042 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: 206L AFT Leg Assembly, RH Stop *NS2*

Start Date: 1/16/15 Start Qty: 3.00 *3*

Required Date: 1/16/15 Req'd Qty: 3.00 *3*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-01-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4866	C								

110 0.00

110

Small Fab

Small Fab

Memo

0.00

3 FF APR 29 2015

ALIGN PILOT HOLES IN D4866-2 WITH PILOT HOLES IN D4870-1 AND D4870-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG.

REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9963 AS PER DWG.

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

3

DAS 39

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Doc/Data									
Equip/Tooling									
Handling/Pre									
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Training									
Transport									
Unapproved									

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Page 3

Item ID: D4866-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L AFT Leg Assembly, RH
 Start Date: 1/16/15 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC5- Inspect part completeness to step on W/O	0.00							DAG 38 9-89
170									
QC	Memo	0.00							
Quality Control									MAY 08 2015
180	Identify as per dwg & Stock Location <u>ST/BQ</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
									3 DAG 27 9-89 MAY 11 2015

DQA: _____ Date: _____



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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item Name: 206L AFT Leg Assembly, RH
Start Date: 1/16/15 Start Qty: 3.00 ***3*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							MAY 12 2015
190									
QC	Memo	0.00							
Quality Control									

MLS MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 128529

128529

Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL32PB5-12 *HI 32PB5-12* Hi-Lok Pin		Purchased	No				Each	480.0000		12			
									**		FF	APR 29 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST553				480					
					M129912			480		12			
D4866-2 *D4866-2* Strut		Manufactured	No				Each	10.0000		3			
									**		FF	APR 29 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST132				10					
					121501			10		3			
D4870-1 *D4870-1* End Fitting, Small		Manufactured	No				Each	24.0000		3			
									**		FF	APR 29 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST142b				24					
					121621			24		3			
D4870-3 *D4870-3* End Fitting, Large		Manufactured	No				Each	24.0000		3			
									**		FF	APR 29 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST142b				24					
					121535			24		3			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Picklist Print

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128529

Parent Item: D4866-042

D4866-042

Parent Item Name: 206L AFT Leg Assembly, RH

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 3.00

Required Qty: 3.00

HL86-5

Purchased

No

Each

1,163.000

12

HI 86-5

FF APR 29 2015

Collar

Location

Loc Qty

Loc Code

ST553

1163

M128228

3

M129022

200

M129864

960

12

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28354**

Purchase Order Date 5/4/2015

PO Print Date 5/7/2015

Page Number 1 of 5

Order From :

VC-PL001

Ship To : DART AEROSPACE LTD

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO KOC 2E0
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	121412 LASER MARKED	D4834-042	5/8/2015 Yes 5/8/2015	4.00	\$4.00	\$16.00
Line Total:						\$16.00
2	128529 LASER MARKED	D4866-042	5/8/2015 Yes 5/8/2015	3.00	\$4.00	\$12.00
Line Total:						\$12.00
3	123301 LASER MARKED	D4868-042	5/8/2015 Yes 5/8/2015	4.00	\$4.00	\$16.00

Note:

5/7/2015



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE May 6, 2015

P.O NUMBER PO28354

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4834-42 LEG ASSEMBLY	4	ALL ITEMS HAVE BEEN LASER MARKED 8015-057
D4866-042 LEG ASSEMBLY	3	
D4868-042 LEG ASSEMBLY	4	
D4878-042 LEG ASSEMBLY	3	
D4879-041 LEG ASSEMBLY	2	
D4880-041 LEG ASSEMBLY	3	
D4880-042 LEG ASSEMBLY	1	
D4881-041 LEG ASSEMBLY	3	
D4881-042 LEG ASSEMBLY	1	
D4882-041 LEG ASSEMBLY	3	
D4882-042 LEG ASSEMBLY	4	
D4803-041 LEG ASSEMBLY	2	



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K0C 2E0 Canada

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Invoice

Number: 7763

Date: May 06, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
28354		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4834-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4866-042	3.00	4.00	✓	12.00
Laser Metal Marking, D4868-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4878-042	3.00	4.00	✓	12.00
Laser Metal Marking, D4879-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4880-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4880-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4881-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4881-042	1.00	4.00	✓	4.00
Laser Metal Marking, D4882-041	3.00	4.00	✓	12.00
Laser Metal Marking, D4882-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4803-041	2.00	4.00	✓	8.00
Sub-Total				\$132.00
13.00% on 132.00				17.16
Total				\$149.16

Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You